

Date: Monday, 8/21/2006 2:16:27 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 28281	
Estimate Number : 10255	
P.O. Number : <i>N/A</i>	Part Number : D22301
This Issue : 8/21/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 28011	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/8/2006 Qty: 160 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 00.11.07 Added inspection level 8, and removed P/O for powder coat EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 11.4744 f(s)  
Lug Extrusion D2423 Extrusion  
Batch: *B23777*

*En 06/09/12 x*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut D2423 extrusion to 0.82"  
Batch: *B23777*

*En 06/09/12 x*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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*PG*



*Issue P.O 2013*



*cd 06/09/13 (160)*

Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine per folio D2230.1  
(Check for crack while loading into the machine.)  
2-Tumble and deburr rough edges after tumbling

*Machine per Lug D2230 Rev F*

4.0	Q02	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*PG*



*Receive & Inspect for*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Transit damage 12/4/14 (80)*

5.0	Q08	SECOND CHECK
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Comment: SECOND CHECK

*2010-20 (80) counted*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/20

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: MOUNTING LUG

Job Number: 28281

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y

06/10/23 x 80

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 10 23 80

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M101575

Y

06/10/23 x 80

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

24/10/25 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51370

24/10/25

80

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

24/10/26 (80)

Job Completion



24/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

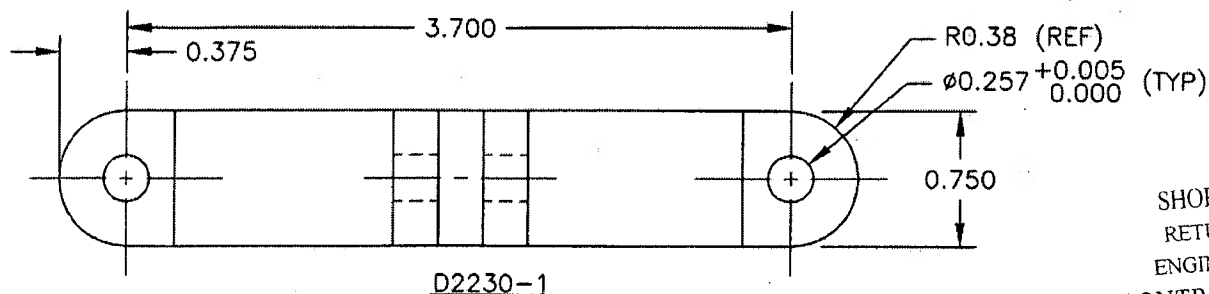
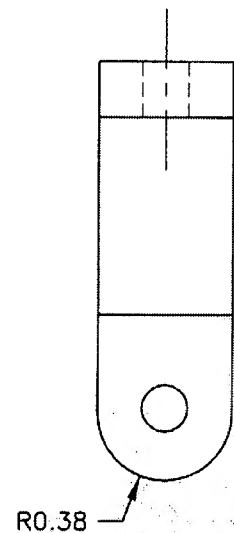
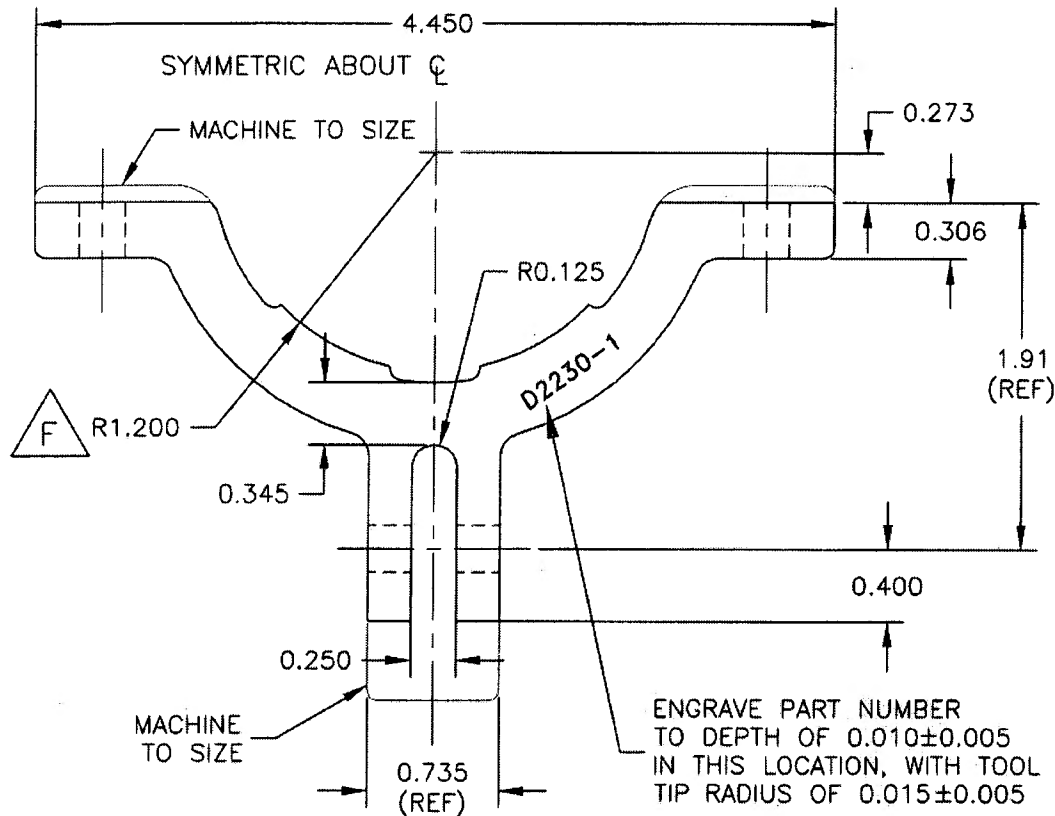
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE	99.12.13			TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30			RE-DESIGN	
D	95.01.04			RE-DESIGN	
E	95.01.04			RE-DESIGN	
F	99.12.13			REDESIGN; R1.200 WAS R1.100	

RELEASED  
99.12.21 DS



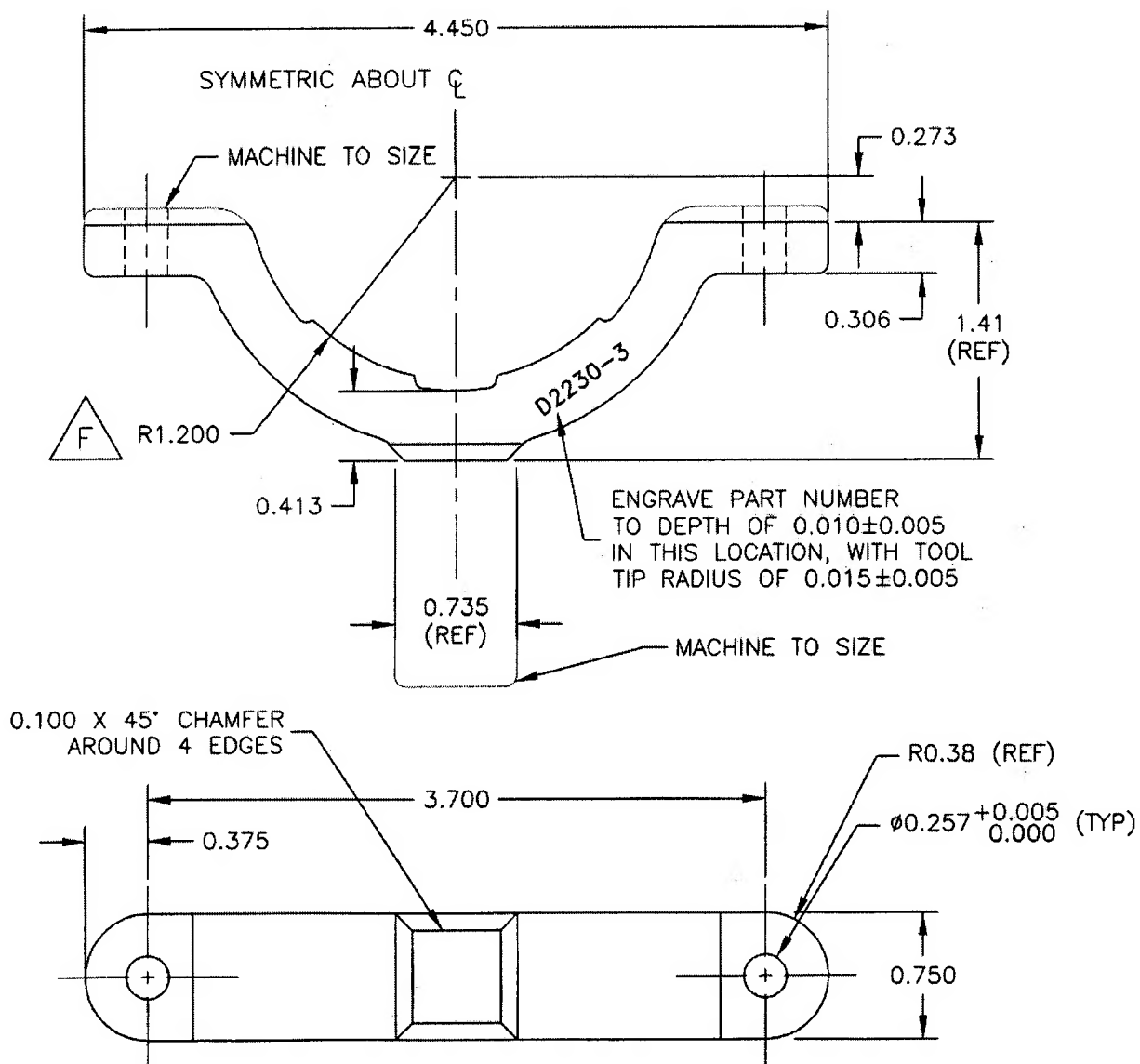
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28281



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
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WORK ORDER  
NO. 28281



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

79 *80*

D 2230-1

Mounting Lug

PO00002013

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Shig Walz*  
Shig (Regular) Walz

Vankleek Hill, October 13, 2006

A large, stylized handwritten signature, likely belonging to Shig Walz, is written in black ink.

